

5/15

DART AEROSPACE LTD	Work Order :	22547
Description: Step Extrusion 04.04.27 05.02.10 CP	Part Number:	D2622-120C
Drawing: D2622 Rev. C1	Qty:	210
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	KJ	05.02.24	210
2	PG	Issue P/O: 1004034 a) Extrude as per Dwg D2622 Rev. C 05.02.10 CP b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	U	05.02.24	210
3	RG	Inspect for transit damage Ensure Certification are attached			
4	QC6	Inspect dimensions per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached. Check hardness with Webster tester	CJL		
5	ST	Identify and Stock as D2622-120C			
6	AC	Cost / part O	S4T	05.03.22	
7	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	02.11.12	New Issue	KJ RF	J

RELEASED
02.11.18 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

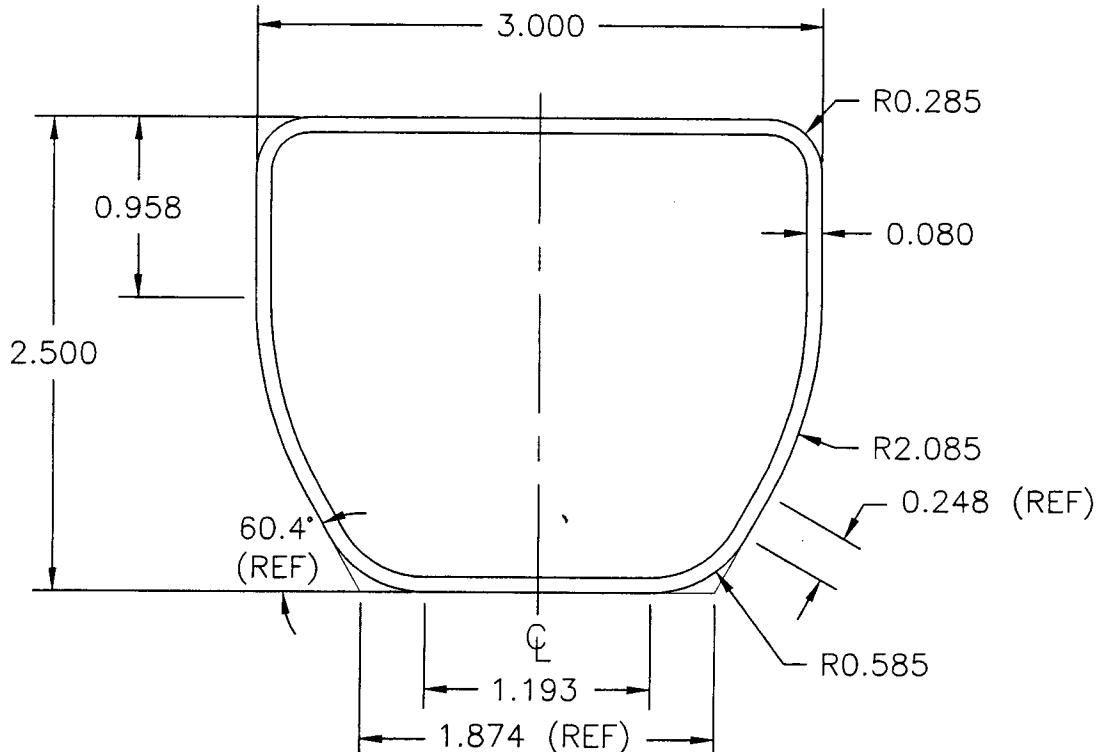
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



RECEIVED
02.09.11

RELEASED
02.09.11

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2622
DATE		SCALE 1:1
02.09.11		STEP EXTRUSION
A	96.11.29	NEW ISSUE
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.
CI	02.10.04	ADD 'REV. A' TO DIE NUMBER.

D2622-XXX STEP EXTRUSION

1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)

2) MATERIAL 6061-T6 (QQ-A-200/8)

3) MANUFACTURED USING BON-L DIE # 897123 REV. A

4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi

MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi

MINIMUM ELONGATION = 8%

5) PART IS SYMMETRIC ABOUT CENTERLINE

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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SUBMIT TO MANAGEMENT
WITHOUT NOTICE

WORK ORDER
NO. 22547

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 23, 2005
02:12 pm

Work Order No	:	0022547	Department Code:
Project Name	:	D2622-120C	Burden Flags : NNNNNNN
Project For	:	WK515	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D2622-120C	Invoice Number :
Description	:	Extrusion	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	210	
Amount Done	:	0	Order Entry No :
Start Date	:	02-23-05	OE Value : 0.00
Est Finish Date	:	03-30-05	
Act Finish Date	:		Est Margin : 0.000%
Drawings Reqd	:	No	Actual Margin : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00